

Work Order ID 51121

August 4, 2009 11:05:07 AM



Page 1

Item ID: D3066-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacer

Start Date: 8/07/09 Start Qty: 40.00



Cust Item ID:

Required Date: 8/21/09 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: NLF Date: 09-08-04 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3066	Rev B						41		

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3066 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

HB 9-8-4

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-8-4



120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 808102106

counted
(+90)

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 Chemical Conversion Coat per QSI005 4.1 0.00



HandFinish

Memo

0.00

Hand Finishing

⇒ 09-08-10 (X41) [Signature]

140 QC3- Inspect Part Finish 0.00



QC

Memo

0.00

Quality Control

2> 502/08/00 (X40) [Signature]

150 Identify as per dwg & Stock Location: step cell 0.00



Packaging

Memo

0.00

Packaging

9/8/11 (40x) [Signature]

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

08-08-11
MF 09-08-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 4, 2009 11:05:07 AM

Page 1 / 1

Work Order ID: 51121

Parent Item: D3066-1RevB

Parent Item Name: Spacer

Comments:

Start Date: 8/07/09

Required Date: 8/21/09

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	145.2290	3.9789			



6061-T6 .080 Sheet



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	145.229	
107272	1.25	
110254	2.5	
110630	42.9353	
112040	34.5437	
112141	64	

107904

107904

HB 9-8-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

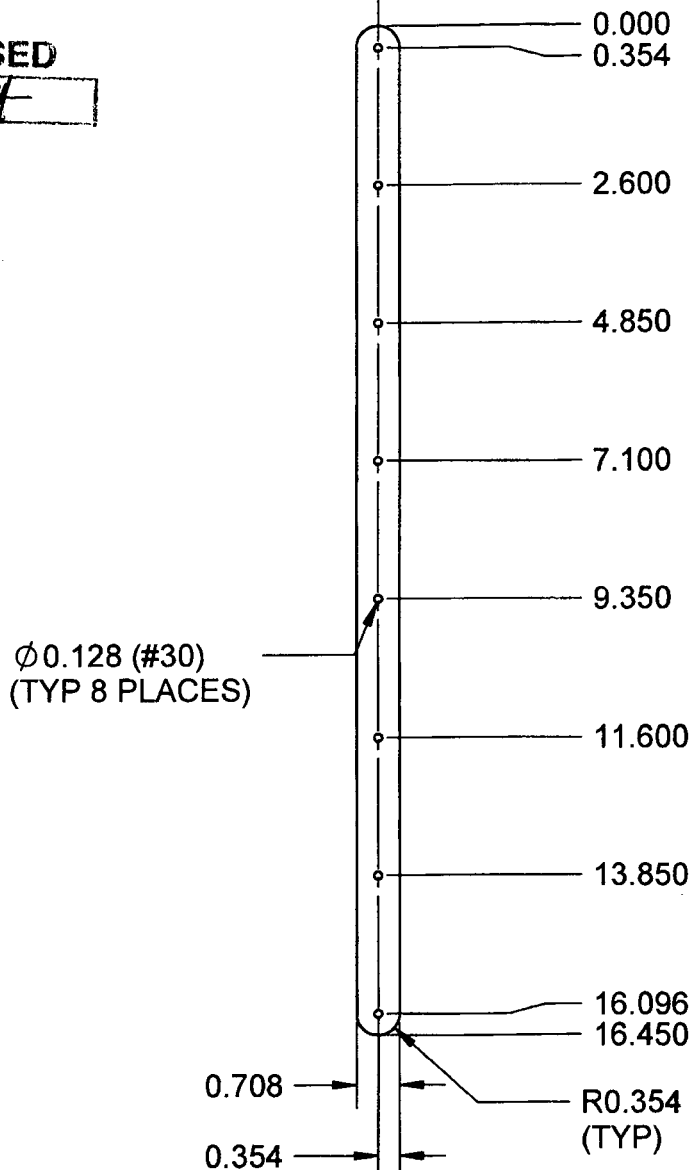
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



DESIGN <i>CP</i>		DRAWN BY <i>CB</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>		APPROVED <i>[Signature]</i>		DRAWING NO. D3066	REV. B SHEET 1 OF 1
DATE 06.05.29			TITLE SPACER SCALE 1:3		
A	02.09.11		NEW ISSUE		
B	06.05.29		ADD 6061-T6 MATERIAL		

RELEASED
de. de. 20 *[Signature]*



#51121
MF
09-08-04

D3066-1 SPACER

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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